

Date: Friday, 25/04/2008 8:21:56 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 38787
 Estimate Number : 12300
 P.O. Number :
 This Issue : 25/04/2008 S.O. No. :
 Prsht Rev. :
 First Issue :
 Previous Run : 38466
 Type : MACHINED PARTS
 Drawing Name : BLADE FITTING
 Part Number : D3488042
 Drawing Number : D3488 / DSK101
 Project Number : N/A
 Drawing Revision : B / D
 Material :
 Due Date : 02/05/2008 Qty: 18 Um: Each
 Written By :
 Checked & Approved By :
 Comment :
 Est Rev: A New Issue 06-02-28 JLM
 Est Rev: B As per Rev B 06-03-30 JLM
 Est Rev: C Now On Doosan Lathe JLM Verified BY: DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6103003	Round Billet, Aluminum
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 36236

20 08/04/05

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN CNC LATHE

1-Turn as per Dwg DSK 101 & Folio FA627

2-Debur

20 08/04/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/04/05

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Debur

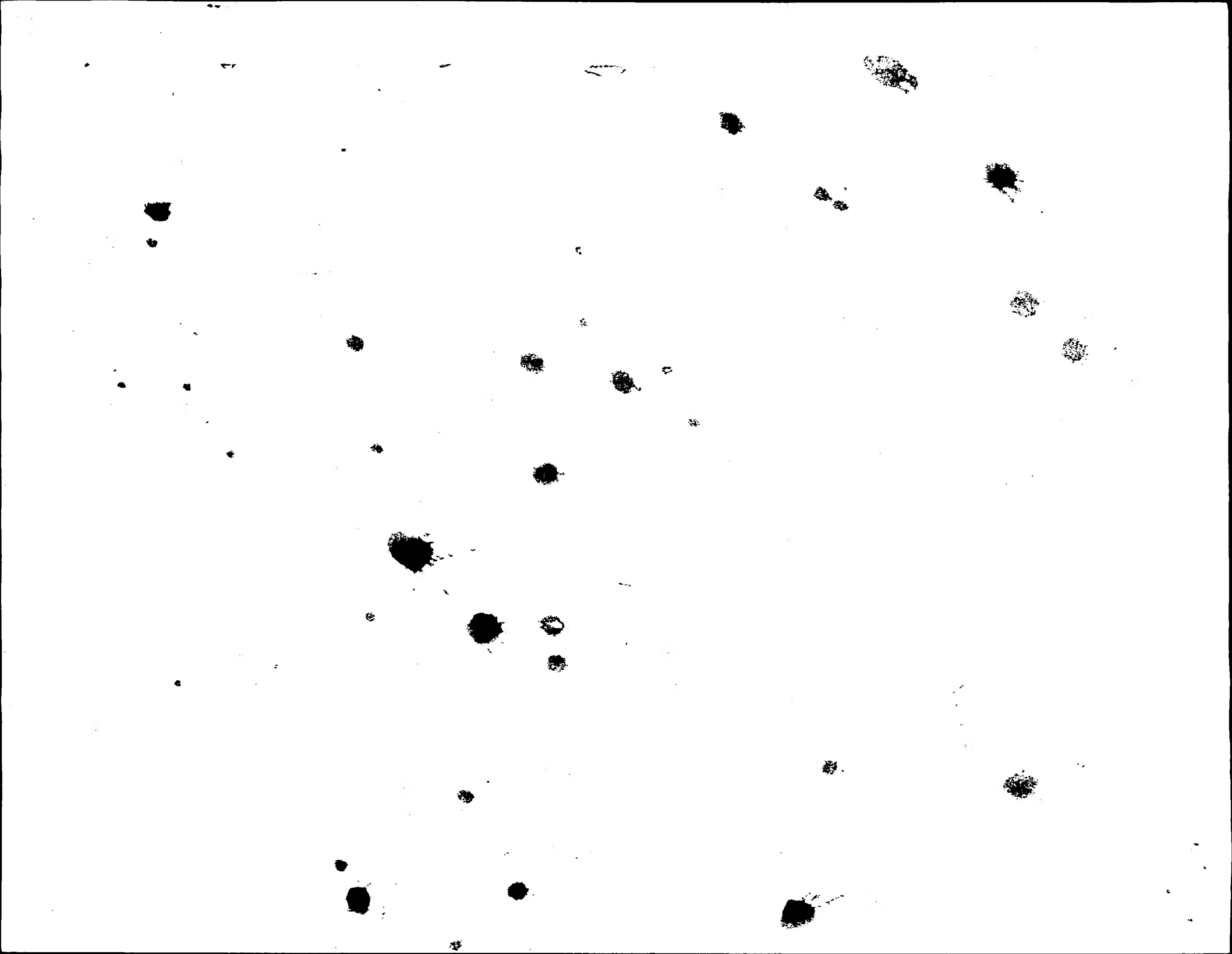
20 08/04/05

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/04/05



Date: Friday, 25/04/2008 8:21:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 38787

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
3:17
3:45

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M100489

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DART AEROSPACE LTD		Work Order:	38787
Description: Blade Fitting, RH		Part Number:	D3488-2
Inspection Dwg: D3488 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

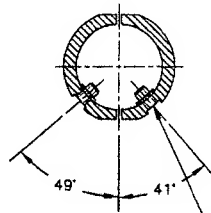
☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.130	✓			
2.620	+/-0.010	2.620	✓			
0.793	+/-0.010	.801	✓			
1.351	+/-0.010	1.344	✓			
1.317	+/-0.010	1.314	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.802	✓			
Ø0.508	+0.006/-0.001	Ø.510	✓			
R0.062	+/-0.010	R.062	✓			
1.500	+/-0.010	1.499	✓			
8.000	+0.030/-0.000	8.024	✓			
11.18	+/-0.030	11.181	✓			
Ø0.484	+0.005/-0.001	Ø.486	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.062	✓			
0.590	+/-0.010	.590	✓			
0.125	+/-0.010	.128	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.500	✓			
Ø0.297	+0.005/-0.000	Ø.302	✓			
Ø0.430	+/-0.010	Ø.435	✓			
0.100	+/-0.010	.108	✓			

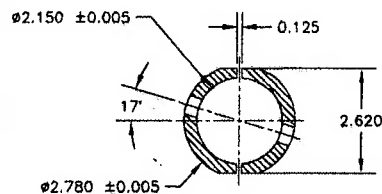
Measured by:	MR	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/04/28	Date:	08/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	<i>[Signature]</i>



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



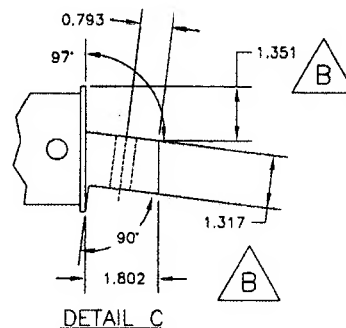
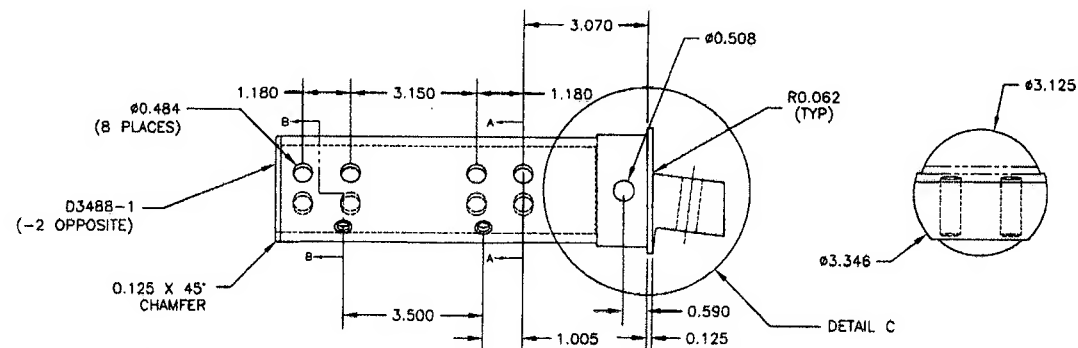
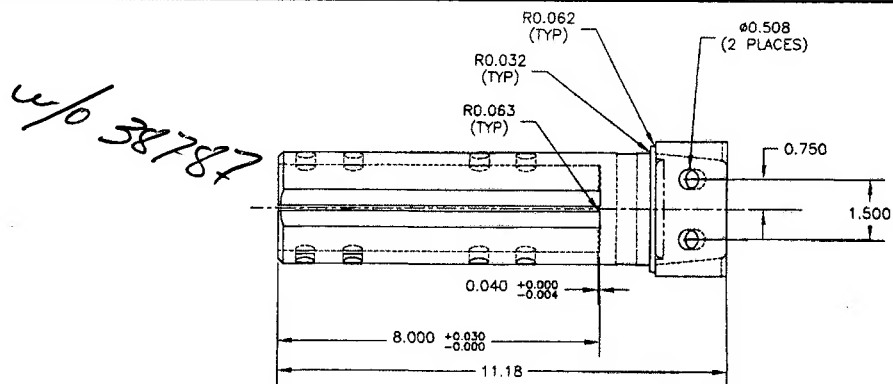
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

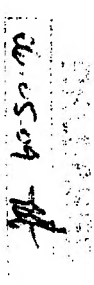
RELEASED
06.03.15 PH
REV 05
EIN #784

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING

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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3488
REV. B
SHEET 1 OF 1
SCALE 1:3



u/o 38787


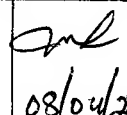

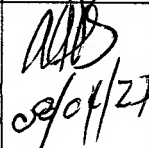
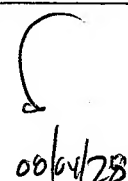
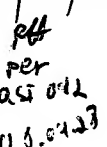
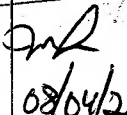
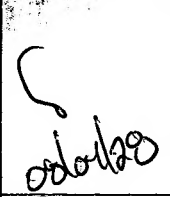
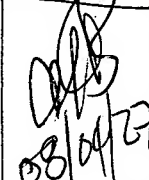



- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3488-042 PAR #: N/A Fault Category: Prod / Machine Parts NCR: (Yes) No DQA: D Date: 08/05/14
QA: N/C Closed: D Date: 08/05/15

NCR: <u>38787</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/26	2.0	1 piece, the interior of the hole have a big groove and the small hole at the wrong position. 2 C. Porgones wrong	 08/04/28	SCRAP and destroy and no replace BE 36236	 08/04/28	 08/04/28	 08/04/27	 08/04/28
06.04.21	2	angle of the cheek Dressing Drill. from end CHATTER @ 5.5" DEEP, AND 0.5" LONG AT MOUNTING HOLE LOCATION	 08/04/28	SCRAP B/C MT MOUNTING HOLE LOCATION and destroy no replace	 08/04/28	 08/04/28	 08/04/27	 08/04/28
		+ CHATTER @ 7.1" FROM END, AND 0.3" LONG		SCRAP and destroy no replace				

NOTE: Date & initial all entries

